Work Order ID 65836

Wednesday, January 26, 2011 11:31:58 AM

Item ID: D2066 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Arm

Start Date: 1/26/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 2/7/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** M Date: 11-01-24 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2066	Rev C								
100		0.00				6X	_____	_____	_____
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727) Use punch Jig DT8012 2-Slide on parts per Dwg and W/O for D2676-043 3-Punch other end to length (28.62") as per Dwg D2066 4-Bend per Dwg D2066 5-Dril								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

MM 11/02/08

SD 11/02/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location:_____	0.00				11/2/9			
Packaging	**Memo**	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00					11/02/10		
QC	**Memo**	0.00							
Quality Control									

MF 11-02-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:32:04 AM

Work Order ID: 65836

Parent Item: D2066

Parent Item Name: Arm

Start Date: 1/26/2011 **Required Date:** 2/7/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP D□ 02.03.18□Added pick list □ NG□
IPP E 07.10.03 removed p/c EC verified by: DD
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			100	Each	8.0000	4	24			
Washer													
				M116007									
				Location			**Loc Qty**		**Loc Code**				
				ST			6						
					107715		6						
				ST335			2						
					105792		2						
D2052		Manufactured	No			100	Each	33.0000	2	12			
Mounting Bracket													
				Location			**Loc Qty**		**Loc Code**				
				ST005			33						
					56290 ✓		6						
					59809 ✓		27						
D2054		Manufactured	No			100	Each	46.0000	2	12			
Bushing													
				Location			**Loc Qty**		**Loc Code**				
				ST005			46						
					56291 ✓		1						
					58392 ✓		15						
					61834 ✓		30						

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:32:04 AM

Work Order ID: 65836

Parent Item: D2066

Parent Item Name: Arm

Start Date: 1/26/2011 **Required Date:** 2/7/2011

Start Qty: 6.00 **Required Qty:** 6.00

D2055	Manufactured	No	100	Each	23.0000	1	6	m-l 11/02/08
Clamp								

Location	Loc Qty	Loc Code	
ST005	23		
55726	3		
58393 ✓	20		6X

D2056	Manufactured	No	100	Each	13.0000	1	6	m-l 11/02/08
Bell Crank								

Location	Loc Qty	Loc Code	
ST006	13		
45542 ✓	5		2X
61705 ✓	8		4X

MS21042L3	Purchased	No	100	Each	3,059.000	2	12	m-l 11/02/08
Nut								

Location	Loc Qty	Loc Code	
ST300	3059		
114784	9		
115835 ✓	550		12X
116391	900		
116540	800		
116549	800		

MS27039-1-18	Purchased	No	100	Each	137.0000	2	12	m-l 11/02/08
Screw								

Location	Loc Qty	Loc Code	
ST292	137		
113845 ✓	39		12x
115589	98		

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Picklist Print

Wednesday, January 26, 2011 11:32:04 AM

Work Order ID: 65836

Parent Item: D2066

Parent Item Name: Arm

Start Date: 1/26/2011 **Required Date:** 2/7/2011

Start Qty: 6.00 **Required Qty:** 6.00

M304TR0.500W.049	Purchased	No	120	f	176.5977	2.386	15.06947

304 RD Tube .500 x .049W

11/02/08

Location	Loc Qty	Loc Code
MAT	172.7647378	
114676	11.9789478	
115010 ✓	160.78579	
MAT017	3.833	
111814	3.833	

15.06947

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

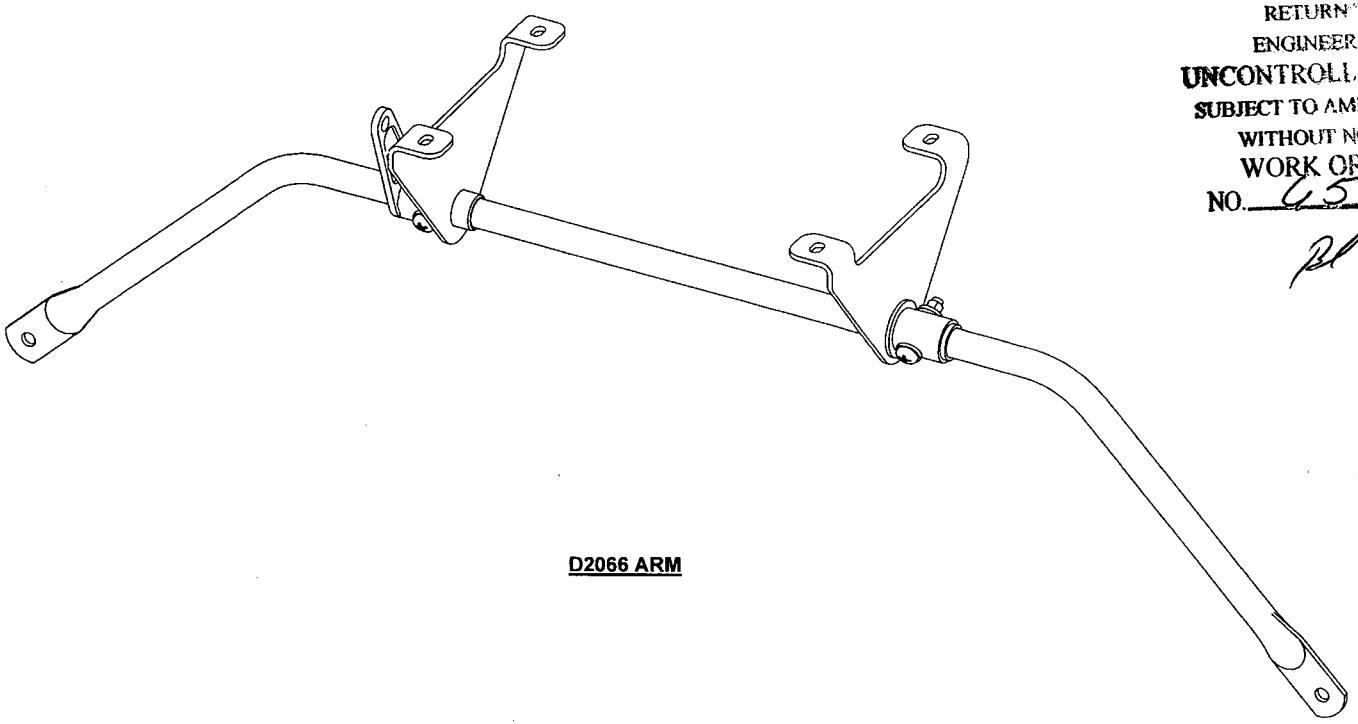
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65834

11-01-26



D2066 ARM

RELEASED
08.07.23

REV.	DESCRIPTION	BY	DATE
C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2066 REV. C
CHECKED		SHEET 1 OF 2
MFG. APPR.		TITLE ARM SCALE NTS
APPROVED		
DE APPR.		
DATE	08.06.12	

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NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.85 lbs

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W/O:		WORK ORDER CHANGES					
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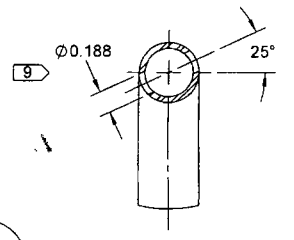
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

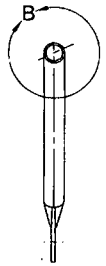
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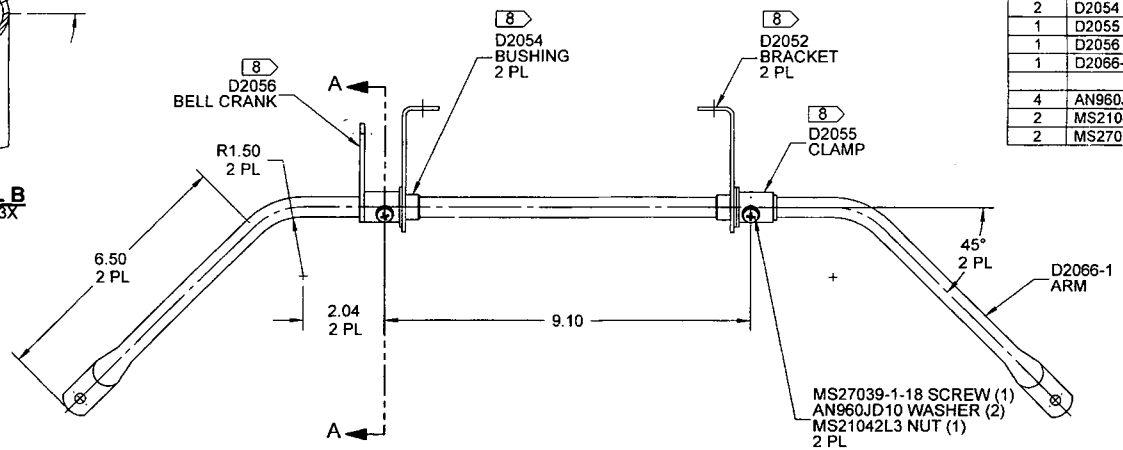
QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW



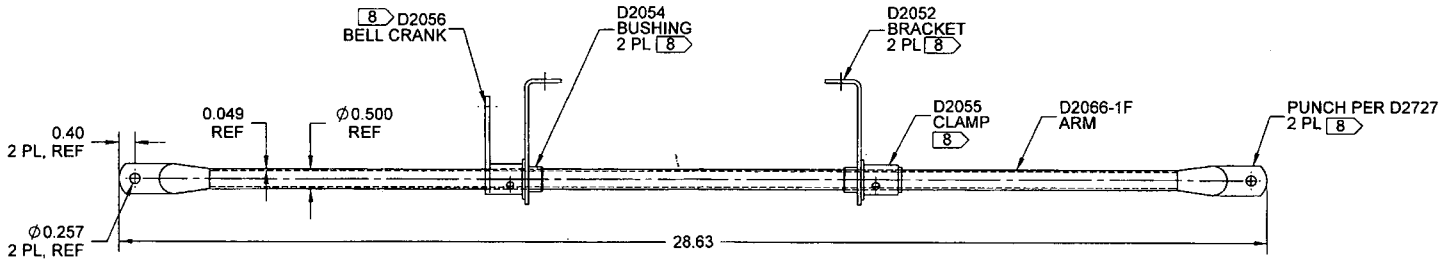
DETAIL B
SCALE 3X
2 PL



SECTION A-A
(SOME PARTS REMOVED FOR CLARITY)



D2066-1 ARM BENDING DETAIL C
(MAKE FROM D2066-1F)



D2066-1F ARM CUT LENGTH DETAIL C

RELEASED
08-07-23 19

NOTES:
1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL C
(REF DART SPEC M304TR0.500W.049)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
9) DRILL Ø0.188 AFTER BENDING

DESIGN	BW	**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2066 REV. C
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE ARM SCALE NTS
DE APPR.		
DATE	08.06.12	

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